



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBST2162-5
Job Sheet 195630



Part No: RBST2162-5

Job Qty: 14 pcs

Part Name: Roller



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/28/19

Job Tracking No:

Due Date: 6/14/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG RBST2100 REV 7 IPP Rev. A 19.04.04 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier Lead Time	
100	Purchasing	14 pcs	6/14/19			AFF001-VC	Purchasing DP
110	Packaging 2-1 - Receive - B4B	14 pcs	6/14/19		0.00 0.00	Packaging 2 - 1 - B4B	
						Packaging 2 - 2 - B4B	
						Packaging 2 - 3 - B4B	
						Packaging 2 - 5 - B4B	
						Packaging 2 - 4 - B4B	
						Packaging 2 - 6 - B4B	
						Packaging 2 - 7 - B4B	
						Packaging 2 - 8 - B4B	
						Packaging 2 - 9 - B4B	
						Packaging 2 - 10 - B4B	
						Packaging 2 - 11 - B4B	
						Packaging 2 - 12 - B4B	
						Packaging 2 - 13 - B4B	DP 6/10/19 2 0 NNT
						Packaging 2 - 14 - B4B	
						Packaging 2 - 15 - B4B	
						Packaging 2 - 16 - B4B	
						Packaging 2 - 17 - B4B	
						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	



Container No: S188505



Part: RBST2162-5

Job No: 195630

Serial No/Batch: S188505

Revision: 7

Inspector:

Exp Date:

Instructions:

Date: 06/07/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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JUN 07 2019

DP

CL

07/2019

					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6	14 pcs	6/14/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	61
					QC 6 - 40	9-89
130	Packaging 3-1 - Stock - B4B	14 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
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					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	14 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	JUN 27 2019
					QC 21 - SA - 53	DAS 70

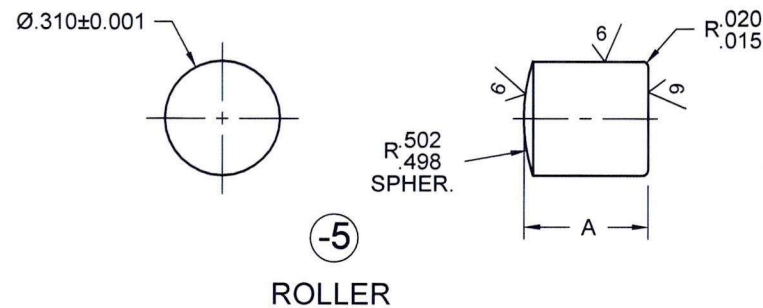
Part Op 100 - ISSUE P/O: H3043554 TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF
 Descriptions: 89031009 ***NOTE*** 1 pin makes 3 pcs.

- 110 - (Receive & Inspect for Damage & Mat'l Certs)
- 120 - (QC6- All purchased or subcontracted products)
- 130 - (Identify as per dwg & Stock Location: _____)
- 140 - (QC21- Final Inspection - Work Order Release)

Job BOM					JUN 07 2019
Part / Item	Component Name	Quantity	Operation	Container	
89031009	Plug and Pin Gauge	4.6620 Ea (.333 ea)	100-Purchasing	1X S046383	4X S049637 C2
RBST2162-5P	Roller	14 Ea (1 ea)	110-Packaging 2-1 - Receive - B4B	S188497	S046388/S049637
Job Allocations					
Operation	Component Part		Required	Inventory	Allocated
100-Purchasing	89031009		5	30	0
110-Packaging 2-1 - Receive - B4B	RBST2162-5P		14	0	0
Part Specifications					
Specifications could not be found.					

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INSPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 - .010, TO .015 - .020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 19449 MJS

19-0502

195630

TOOL #	A +.001 -.001	MATERIAL		
RBST2120	.335	.310 MINUS	GAUGE PIN	MSC#89031009
RBST2128	.335	.310 MINUS	GAUGE PIN	MSC#89031009
RBST2162	.335	.310 MINUS	GAUGE PIN	MSC#89031009

RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; ROLLER (QTY. 3)	
DWG NO. TOOL# (see chart)-5	REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 ANGLES ± 5° XX ± .01 X ± .1	DRAWN BY: PERRITT APPROVED: <i>D West</i> HEAT TREAT RC 55-60 FINISH SPEC USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-23-08 SHEET 4 of 9

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043554



Supplier: AFF001-VC
Affutage K.G. Inc.
11455 Philippe Panneton Ave.
Montreal
QC
H1E 4M1 Canada
Phone: 514 323 0192 514 323 6631
Fax: 514 323 6631

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043554

PO Date: 5/28/19

Due Date: 6/7/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
MAY 30 2019

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		RBST2162-5P		Roller : CUT PIN TO SIZE AS PER DWG RBST2162-5	Firmed	-	6/7/19	12 Ea 14 JUN 07 2019 CL	0 Ea	12 Ea	\$16.00/Ea	\$192.00
Grand Total:												\$192.00

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
~~A020 CERTIFICATION OF MATERIAL CONFORMANCE~~
~~A022 DOCUMENT SPECIAL REQUIREMENTS~~
~~A030 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS~~
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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1. The first part of the document is a letter from the President of the United States to the Congress, dated January 1, 1801. It is a very important document, as it is the first official communication from the new President to the new Congress. The letter is written in a formal, dignified style, and it contains a great deal of information about the new administration and the future of the country.

2. The second part of the document is a letter from the President to the Congress, dated January 1, 1801. It is a very important document, as it is the first official communication from the new President to the new Congress. The letter is written in a formal, dignified style, and it contains a great deal of information about the new administration and the future of the country.

AFFUTAGE K.G. INC. K.G. GRINDING INC.

11455 avenue Philippe Panneton
Montréal, Québec H1E 4M1
Tel: (514) 323-0192
Fax: (514) 323-6631

Packing Slip

Packing Slip No.: 10748
Date: 05-06-2019
Page: 1

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Order No.: HB043554	Sold By:
Shipped By:	Tracking No.:

Item No.	Unit	Description	Ordered	Quantity Shipped	B/O
D.Modifiication	Each	CUT PIN TO SIZE AS PER DWG RBST2162-5	DAS 12 61 14 9-89	12 14 CL	JUN 07 2019
RECEIVED JUN 06 2019 DART AEROSPACE LTD.					

Affutage K.G. Inc. POHB043517 \ POHB043554



Chantal Lavoie

Today, 8:40 AM

Derick Paul



Reply all

Bon matin Derick,
Non pas de c of c requi.
Chantal



Derick Paul

Salut chantal, j'ai reçu affutage K.G. mais je me demande si j'ai besoin d'un c.of.c pour le POHB043517 et POHB043554 parce qu'il on une job relia a...

Today, 8:38 AM